



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 178804



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New Issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		SLC
110	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		SLC
120	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC9		CPL
130	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		CPL
140	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		BE-B 18-06-27
150	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2		CPL
180	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		SLC
190	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC10		SLC
200	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		SLC
210	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		SA 18-07-04
220	Powdercoat	10 pcs	7/20/18	7/20/18	0.00	2.90	Powdercoat1		BR 18-7-10
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish3		BE-B 18-07-11
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		36
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 19 2018
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		Smf
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		21 JUL 23 2018
275	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		21 JUL 23 2018
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21 JUL 23 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jlg DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1/134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:45 OVEN TEMPERATURE: 600° FINISH TIME: 3:15

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5077589
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5068282
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5081395
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5081379 @ 5084685 (3)
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	256	0
	D3219-1	20	155	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	32	0
	D3066-1	20	273	0
	MS20600-AD4W4	160	1,611	0
250-Packaging	AN3-35A	20	308	0
	AN4-13A	80	1,217	0
	AN5-36A	20	306	0
	D2230-3	40	20	0
	D2618	20	154	0
	D2856-400-720	20	60	0
	D3235-1	20	246	0
	D3278-041	10	46	0
	MS21042L3	20	1,903	0
	MS21042L4	80	2,976	0
	MS21042L5	20	659	0
	NAS1149D0363J	40	2,225	0
	NAS1149D0463J	160	5,149	0
	NAS1149D0563J	40	2,099	0

Part Specifications
Specifications could not be found.

Plex 6/7/18 2:32 PM dart.lacelle.linda

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ml 17 June 2019

DQA: _____ Date: JUN 20 2018

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐



Work Order: <u>178804</u> <u>5088397</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D350-591-311</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☒		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
NCR No. <u>19-7142</u>		Suspected Unapproved		QTY Effective: <u>110</u>		Disposition <u>D</u>		MRA (QS1042) Approval <u>PD</u>		Completed By <u>18-06-20</u>	
Date: _____		Step #: _____		Description Work Order Deviation		Disposition		QC / QA Coordinator <u>PD</u> Approval <u>18-06-20</u>		Lead hand / Supervisor <u>9-89</u>	
<u>- During inspection D3219-1 BRACKET was found cracked.</u>		<u>Scrap / Destroy</u>		<u>NO REPLACE</u>		JUN 20 2018		JUN 20 2018		JUN 20 2018	
						Approval Verification <u>24</u>		Approval Verification <u>24</u>		Approval Verification <u>24</u>	
Root Cause		FAULT CATEGORY									
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong	
Design		Operator ☒		Bending		Set-up		Folio/Program		Outside Dimensions	
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing	
Material ☒		Use for Testing		Cuffs		Contamination		Out of Sequence		Drawing	
Internal Transport		Poor Information		Crushing		Counter sink		Off-set		Finish	
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mis-labeled		Misread	
LOA		Product Improvement		Wave/Twist In Tube		Instructions Incomplete/Unclear		Fit/Function		Turning Sequence	
Substation		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center			
Past Expiry Date		Manufacturing Process		OTHER: _____							
Misidentified		Past Due									



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004319	S090716	AN3-35A	Bolt	s067891	ST348	20
004319	S090712	AN4-13A	Bolt	s067892	ST344	80
004319	S090711	AN5-36A	Bolt	s068656	ST336	20
004319	S090791	D2618	Bushing	s082275	ST008	20
004319	S090792	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	20
004319	S090693	MS21042L3	Nut	s078167	ST303	20
004319	S090692	MS21042L4	Nut	s062378	ST303	80
004319	S090688	MS21042L5	Nut	s058178	ST303	20
004319	S090691	NAS1149D0363J	Washer	s015269	ST263	40
004319	S090690	NAS1149D0463J	Washer	s062379	ST263	160
004319	S090689	NAS1149D0563J	Washer	s068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D3235-1 5069956
D2230-3 5085080

(18)

(20)

Plex 7/11/18 11:13 AM Dart.joly.jocelyne



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D350-591-311
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Cpl
96001 SCRAP

Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

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Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		
120	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC9		
130	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
140	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		
150	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		
190	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC10		
200	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		
220	Powdercoat	10 pcs	7/20/18	7/20/18	0.00	2.90	Powdercoat1		
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish3		
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1.134 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:45 OVEN TEMPERATURE: 300 FINISH TIME: 3:15

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5081379 @ 5084685
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5067891
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5067892
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5068656
D2230-3	Mounting Lug	40 Ea (4 ea) 36	250-Packaging	5082275
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5070659
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	5069956
D3235-1	Mounting Lug	20 Ea (2 ea) 18	250-Packaging	5070688
D3278-041	Support Assembly	10 Ea (1 ea) 9	250-Packaging	5078167
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5062378
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5058148
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5062379
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5068660
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	256	0
	D3219-1	20	155	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	32	0
	D3066-1	20	273	0
	MS20600-AD4W4	160	1,611	0
250-Packaging	AN3-35A	20	308	0
	AN4-13A	80	1,217	0
	AN5-36A	20	306	0
	D2230-3	40 36	20	0
	D2618	20	154	0
	D2856-400-720	20	60	0
	D3235-1	20 18	246	0
	D3278-041	10 9	46	0
	MS21042L3	20	1,903	0
	MS21042L4	80	2,976	0
	MS21042L5	20	659	0
	NAS1149D0363J	40	2,225	0
	NAS1149D0463J	160	5,149	0
	NAS1149D0563J	40	2,099	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004319	S090840	AN3-35A	Bolt	S090716	ST348	18
004319	S090843	AN4-13A	Bolt	S090712	ST344	72
004319	S090844	AN5-36A	Bolt	S090711	ST336	18
004319	S092846	D2230-3	Mounting Lug	S098979	ST521	40
004319	S090845	D2618	Bushing	S090791	ST008	18
004319	S090846	D2856-400-720	Abrasion Strip 4" X 7.20"	S090792	ST418	18
004319	S090872	D3235-1	Mounting Lug	S099956	ST522	18
004319	S090871	D3278-041	Support Assembly	S076688	ST522	9
004319	S090847	MS21042L3	Nut	S090693	Cycle Retire	18
004319	S090848	MS21042L4	Nut	S090692	ST303	72
004319	S090849	MS21042L5	Nut	S090688	ST303	18
004319	S090850	NAS1149D0363J	Washer	S090691	ST263	36
004319	S090851	NAS1149D0463J	Washer	S090690	ST263	144
004319	S090852	NAS1149D0563J	Washer	S090689	ST263	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/17/18 2:31 PM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step - High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step - Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step - High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	12	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the Installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]